

# Work Order ID 56779

March 10, 2010 7:17:39 AM



Page 1

Item ID: D3476-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Duct

Start Date: 3/10/10

Start Qty: 2.00



Cust Item ID:

Required Date: 3/15/10

Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3476

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg D3476

Dwg Rev: *8*

Prog Rev: *B*

*304 1018*

*10-3-15*

*(9)*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*10-3-15*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*810603/157*

*(xy)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 56779

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Page 2

Item ID: D3476-1

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Setup Start



Revision ID:

Stop



Item Name: Duct

Start Date: 3/10/10

Start Qty: 2.00



Cust Item ID:

Required Date: 3/15/10

Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr if necessary.

2-Roll as per Dwg D3476

3-Spot weld as per Dwg D3476 and Dart QSI 018

SB 10/03/18

⇒ m.l 10/03/18

(4X)

140

0.00



QC11- Inspect spot weld per QSI004

QC

Memo

0.00

Quality Control

SB 10/03/18

(4)

150

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

S 10/03/18

(4)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 56779

March 10, 2010 7:17:40 AM



Page 3

Item ID: D3476-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Duct

Start Date: 3/10/10 Start Qty: 2.00



Cust Item ID:

Required Date: 3/15/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Identify as per dwg & Stock Location: 160

0.00



Packaging

Memo

0.00

Packaging

*10/13/18* (4)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/03/24*

*CL10/3/19*

# Picklist Print

March 10, 2010 7:17:38 AM

Page 1

Work Order ID: 56779



Parent Item: D3476-1



Parent Item Name: Duct

Start Date: 3/10/10

Required Date: 3/15/10

Comments: IPP Rev:A New Issue 06-02-03 JLM

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S26GA		Purchased	No			100	sf	170.5262	0.8600	1.75		



304/316 0.018 SHEET

10-3-15

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

170.5261895

105591

0.39

107021

1.21

108415

3.19

109398

69.7361895

112885

96

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
169398  
\_\_\_\_\_

④

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**NOTE:** Date & initial all entries



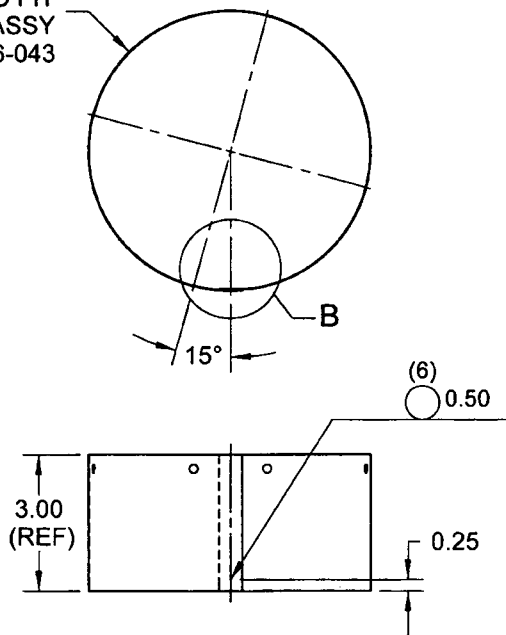
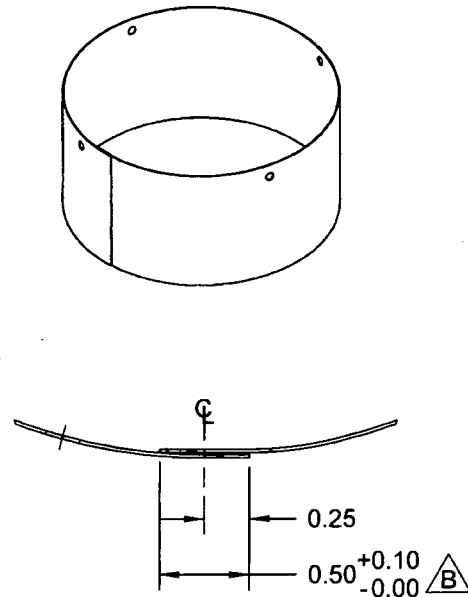
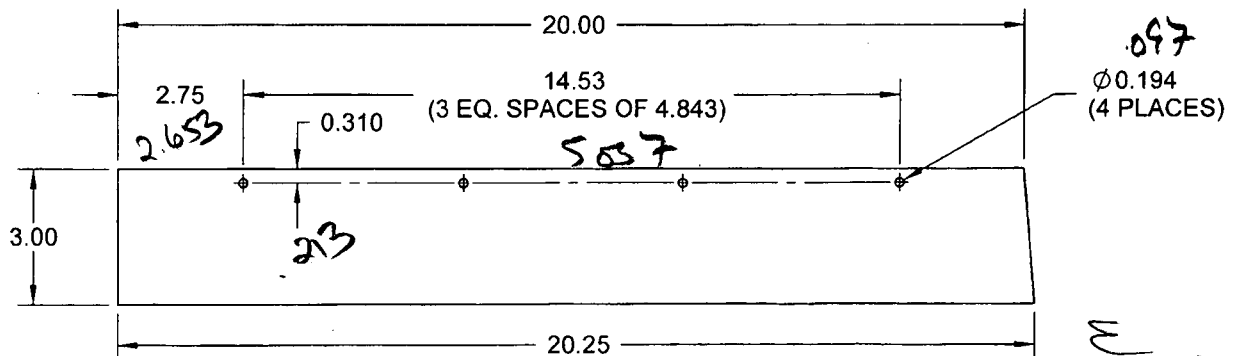


**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3476	REV. B SHEET 3 OF 7
DATE 08.12.19		TITLE BLOWER MOTOR ADAPTER	SCALE 1:4

**RELEASED**  
*[Handwritten: 08/21/2019]*

△  $\phi 6.16$  (REF)  
FORM TO FIT  
D3476-3 AT ASSY  
OF D3476-043

**D3476-1 DUCT****DETAIL B  
SCALE 1:1****△ D3476-1F DUCT FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH  
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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**SPOT WELD TEST RECORD**  
**AMS-W-6858A**  
**CLASS 'C'**

**TEST NO#:** 79

**EMPLOYEE:** Marc Gregory

**PART NUMBER:** D3476-1

**JOB NUMBER:** B 56779

**MATERIAL TYPE:** 304

**MATERIAL THICKNESS:** .017

**GROUP SPECIFICATION**

- |                                     |                               |
|-------------------------------------|-------------------------------|
| <input type="checkbox"/>            | Group 1: Aluminum & magnesium |
| <input type="checkbox"/>            | Group 2: Iron; nickel; cobalt |
| <input checked="" type="checkbox"/> | Group 3: Titanium <u>SS</u>   |

**TEST RESULTS**

	<b>PASS</b>	<b>FAIL</b>	
<b>VISUAL:</b>	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]	
<b>PENETRATION:</b>	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]	
<b>PULL STRENGTH:</b>	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]	<b>PSI Reading:</b> _____

**Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)**

**DATE OF TEST COUPON:** 10/03/18  
**QUALIFIER:** SS

# Dart Aerospace Ltd

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